

Date: Wednesday, 3/21/2007 1:59:10 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 31401	
Estimate Number : 12801	
P.O. Number : N/A	Part Number : D35377
This Issue : 3/21/2007 S.O. No. : N/A	Drawing Number : D3537 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : NA	Drawing Revision : A
Previous Run : 31165	Material : N/A
Written By : <u>JA 07.03.21</u>	Due Date : 3/30/2007 Qty: 10 Um: Each
Checked & Approved By : <u>JA 07.03.21</u>	
Comment : Est.Rev:A New Issue 07-03-12 ec	

## Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.1512 sf(s)/Unit Total : 1.5120 sf(s)  
M304S16GA Stainless steel sheet 0.063" thick  
Batch: M101873

JAN 07/03/24

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D3537  
Dwg Rev: A  
Prog Rev: A

2-Deburr if necessary

JAN 07/03/24

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JAN 07/03/24

(10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Jan 07/03/25 (10)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
Deburr if necessary  
Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326.

SB 07/03/28

(10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 1:59:10 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31401

Part Number: D35377

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

N/A

0703-28 (10)

(PTD)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

MAR 755

Weld hardcoat as per Dwg D3437

FC 07/04/03 (10)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/03 (10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/03 (10)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 07/04/04 (10)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/4/4 (10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/4/4 (10)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/04

Job Completion



11 07/04/04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-03-28	60	Remove Toggle. Perm. Change. <i>[Signature]</i>				<i>[Signature]</i> 07-03-28	<i>[Signature]</i> 07-03-28	

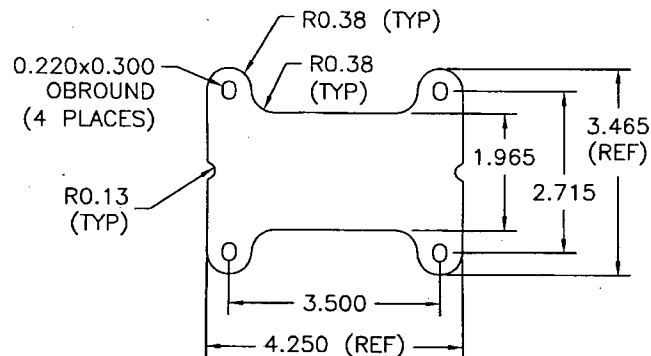
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/04

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

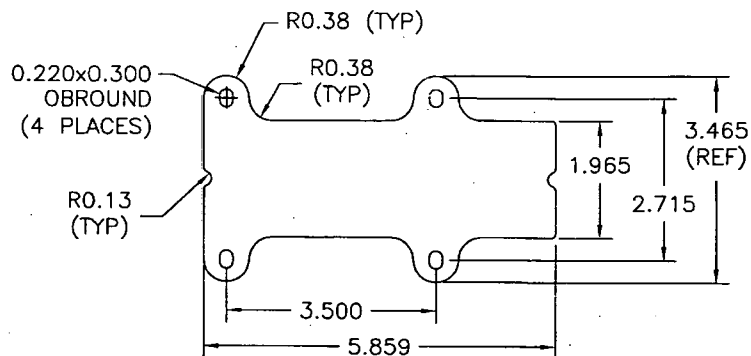
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

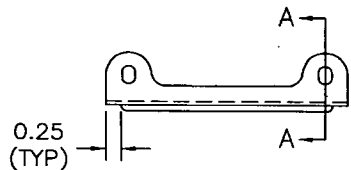
### D3537-1F FLAT PATTERN



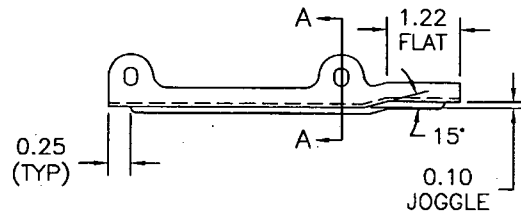
### D3537-3F FLAT PATTERN



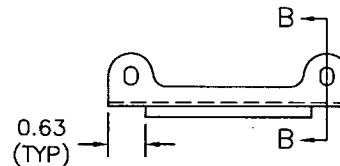
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



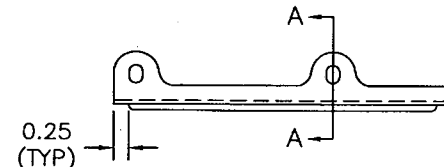
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



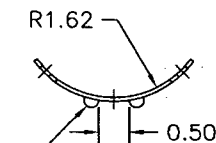
### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

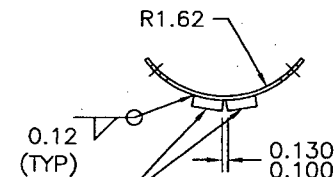


### SECTION A-A



2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.063 TO 0.125 THICK

### SECTION B-B



D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

RELEASED

07.02.12

### NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE  
(0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

NO. 21401  
WORK ORDER  
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ENGINEERING

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A	06.11.06	NEW ISSUE
DESIGN CB	DRAWN BY CB	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED PH	APPROVED	DRAWING NO. D3537
DATE 06.11.06		TITLE WEARPAD
		REV. A SHEET 1 OF 1 SCALE 1:2

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31461
<b>Description:</b> Wear Pad		<b>Part Number:</b> 035377
<b>Inspection Dwg:</b> 03537 <b>Rev:</b> A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.859	+/-0.010	5.860	✓		Vern	
B	3.465	+/-0.010	3.460	✓		Vern	
C	2.715	+/-0.010	2.710	✓		Vern	
D	1.965	+/-0.010	1.971	✓		Vern	
E	0.220	+/-0.010	0.222	✓		Vern	
F	0.300	+/-0.010	0.306	✓		Vern	
G	0.063	+/-0.010	0.055	✓		Vern	
H							
I							
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

<b>Measured by:</b> SAM	<b>Audited by:</b> EN	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/03/24	<b>Date:</b> 07/03/24	<b>Date:</b>	N/A
<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b> <b>Approved</b>
		New Issue	KJ/RF

